

5/22

DART AEROSPACE	Work Order:	23188
Description: Clamp	Part Number:	D2947
Drawing: D2947 Rev.A1	Qty:	200

RF 03.05.06

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	AL	05/05/09	200
2	PURCHASING	Issue P/O: 7008017 Laser cut as per Dwg D2947 Material release note required	U	0505.11	200
3	RECEIVING	Receive and inspect for transit damage Ensure material release note attached	CL	05/06/09	200
4	QC	Inspect Level 6 (9.312" center to center)	2	05-07-04	200
5	METAL	Tumble & Deburr any rough edges after tumbling	SM	05-07-05	200
6	METAL	Bend as per Dwg D2947 N/A	2	05-07-06	200
7A	QC	Inspect Level 5	2	05-07-06	200
7B	GA	Tumble	2	05-07-06	200
8	STORES	Identify and Stock	CL	05/07/06	200
9	EXPEDITING	Close W/O 4899 Cost / Part: 5.14 5.14	AL	05/07/15	200

Rev	Date	Change	Revised By	Approved
A	00.01.14	New issue	EC	

RELEASED

R 00.01.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



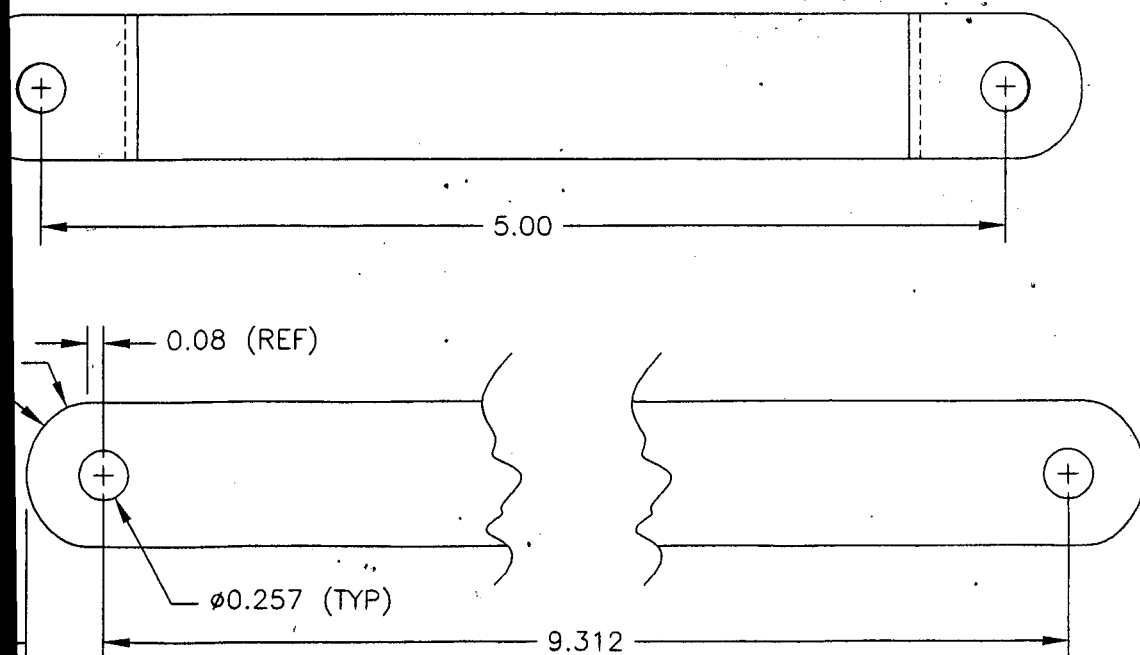
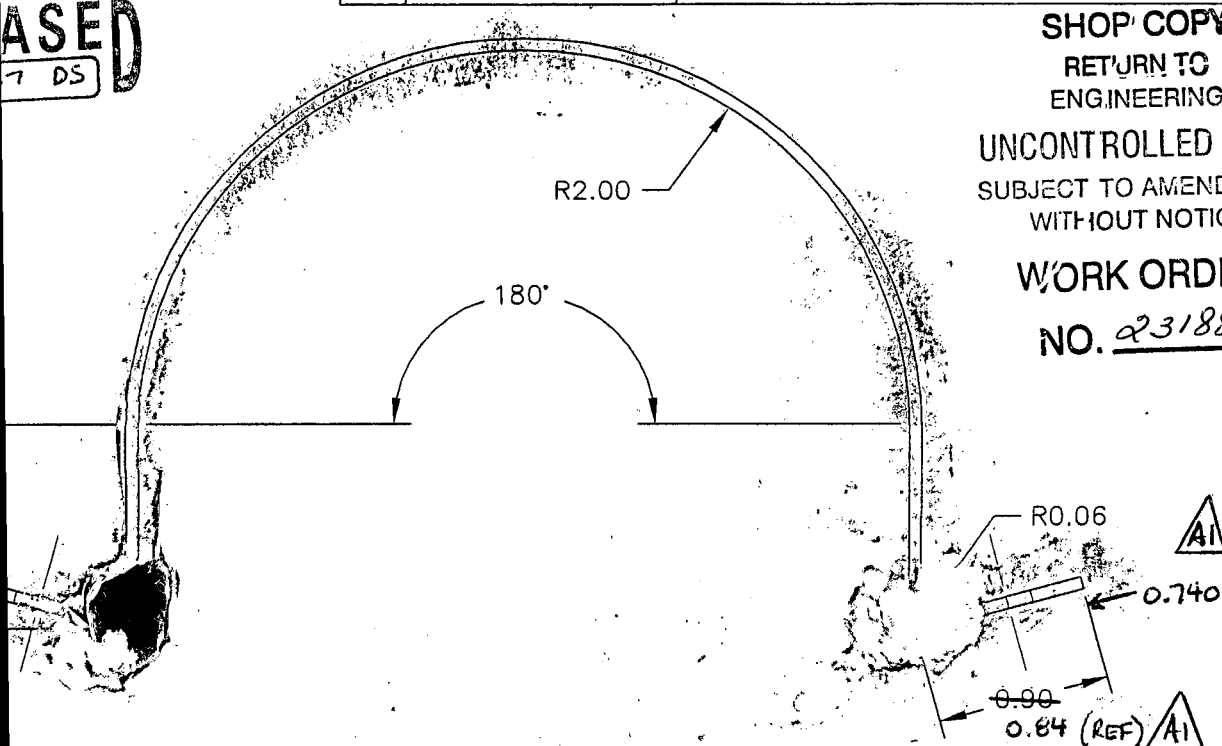
DESIGN JP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JP	APPROVED JP	DRAWING NO. D2947	REV. A SHEET 1 OF 1
DATE 00.01.06		TITLE CLAMP	SCALE 1:1
A	00.01.06	NEW ISSUE	

ASED
7 DS

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 23188



D2947 FLAT PATTERN

MATERIAL: AISI 304/316 SS 0.063 THICK x 0.75 WIDE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

CP
01.09.07 ADD 0.740 DIMENSION; 0.84 WAS 0.90
A1

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 06, 2005
09:55 am

Work Order No : 0023188
Project Name : D2947
Project For : WK522
Work Order Type : Main
Main WO Number :
House Part Number : D2947
Description : Clamp
Manufactured : Yes
Amount Req'd : 200
Amount Done : 0
Start Date : 05-05-05
Est Finish Date : 05-26-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00	0.00	0.00
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00	0.00	0.00
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00	0.00	0.00
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00	0.00	0.00
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00	0.00	0.00
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00	0.00	0.00
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. <u>2</u>		OUR JOB NO <u>J0127845</u>		SHIPPING MEMO <u>0305232</u>		
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>--</u>	<u>200 PCS</u>	<u>2008017</u>	<u>D2947</u>	<u>A</u>	<u>CLAMP</u>	<u>A</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
<u>S.S.T 304</u>		<u>THYSSENKRUPP NIROSTA</u>		<u>483081 ATT'D</u>		
PROCESS			PROCESSOR		RELEASE NOTE #	
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>			<u>GFI</u>	<u>CONFORMS</u>	
2						
3						
4						
5						
6						
7						
8						
9						

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 03 JUNE 2005

G.F.I. Q.C. REP.

A. Harlow





08-SEP-2004 13:58

KTN ABNAHME

+49 2151 834106

S.01/01

 ThyssenKrupp Nirosta Ein Unternehmen von ThyssenKrupp Stahl AG		ABNAHMEPRUEFZEUGNIS B INSPECTION CERTIFICATE B CERTIFICAT DE RECEPTION B BESCHEINIGUNG 3.1.B NACH EN 10204		Zeugnis-Nr.: 041958777 Certificate No.: N° du certificat:		Datum: Date: 08.09.2004		1				
47794 Krefeld Postfach THYSSENKRUPP NIROSTA 2275 HALF DAY ROAD, SUITE 160 USA- BANNOCKBURN, IL 60015 USA			Besteller: Purchaser: Commandant: THYSSENKRUPP NIROSTA			Bestell-Nr.: Order-No.: Commande N°: OC 00001882 - PO C97242			Unter Auftrags Nr.: Our Order No.: Notre commande: 263895		Lieferenzettel Nr.: Delivery Note No.: Avis d'expédition N°: 86324912	
Erzeugnisform: Produkt: Produit: Band/Coil/Rouleau Werkstoff: Quality: Nuance: TYPE 304 / 304 L			Lieferbedingungen/Terms of delivery/Conditions de livraison: ASTM A 240/A 240M-04a ASME SA 240 A02 ASTM A 888-03			Zeichen d. Sachverständigen: Inspector's stamp: Poinçon de l'expert: 						
Position Item Poste	Stückzahl Quantity Nombre	Gewicht/Masse ASME LBS	Maße/Produkt dimensions/Dimensions du produit inch			Erzeugnis-Art Mat. Lm. Mode de fus	Schmelz-Nr. Cast-No. Coulée N°	Los-/Band-Nr. Lot-/Coil-No. Lot /Rouleau-N°	Ausführung Finition Fini			
3	3	42725	0,0691 x 48,0000			AOD	483081	4848	3C2B			
Schmelz-Nr. Cast-No. Coulée N°	C %	Si %	Mn %	P %	S %	Cr %	Ni %	N %				
483081	0,024	0,39	1,24	0,023	0,001	18,12	8,03	0,066				
Probe-Nr./Ref. Test No. Epr.N°	Los-/Band-Nr. Lot-/Coil-No. Lot /Rouleau-N°	Rp0,2 PSI	Rp1% PSI	Rm PSI	A2" %	HV						
157 A	4848 00	39281	44220	91920	59,0	164,0						
157 E	4848 00	40018	45090	92936	54,3	185,0						
Probentyp sur Walzrichtung QUER												
Verwechslungsprüfung (Spektralanalyse) / Test of identity (spectrum analysis) / Contrôle d'identification (analyse spectrale) I.O. Maße - Oberflächen/Dimensions - Surface I.O. Prüfung auf Interkrist. Korros. / Test of intercryst. corros. / Test de corros. intercryst. ASTM A 262 D2a PRACTICE E D.B.												
ThyssenKrupp Nirosta GmbH DIESES ZEUGNIS WURDE VOM RECHNER ERSTELLT WERK KREFELD, ABNAHME BUTZEN WERKSSACHVERSTAENDIGER TEL: 02151-832447 FAX: 02151-834106 WAERMEBEHANDLUNG : 1050 GRAD C / LUFT TRAITEMENT TERMIQUE : 1050 GRAD C / AIR HEAT - TREATMENT : 1050 DEGREE / AIR <div style="text-align: right;"><i>Car.</i></div>												